| Item ID: | D2325 | | Accept | *N9000401nn* | Setup | Start | *NS1* |

Revision ID:

| Item Name: | Support Gusset (350 Basket) | | | | | Stop | *NS2* |

| Start Date: | 5/21/2013 | Start Qty: 4.00 | *4* | | Cust Item ID: |
| Required Date: 5/22/2013 | Req'd Qty: 4.00 | *4* | | Customer: |

Reference:

| Approvals: | Process Plan: _MJ_ | Date: _B-5-21_ | Tooling: _____ | Date: _____ | Run | Start | *NR1* |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | *NR2* |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2325	Rev B								
100		0.00							
100 Waterjet	FLOW WATER JET	0.00				1	0		Jm13-5-21
FLOW CNC Waterjet 304.063	Memo 1-Cut as per Dwg D2325 Dwg Rev: _5_ Prog Rev: _B_								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	Memo	0.00				1	0		Jm13-5-21
Quality Control									

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: Date:

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		_____
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		_____
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		_____
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

| Item ID: | D2325 | | | Accept | *N9000401O0* | Setup | Start | *NS1* |

Revision ID:

Item Name: Support Gusset (350 Basket)   Stop *NS2*

Start Date: 5/21/2013   Start Qty: 4.00   *4*   Cust Item ID:

Required Date: 5/22/2013   Req'd Qty: 4.00   *4*   Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____   Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	BS 21			1			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location:_____ Memo *****STOCK IN BASKET CELL*****	0.00 0.00							
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**	
Part No. _____	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐	
	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐	
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio

- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions

- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____
_____

Work Order ID:	101913							
Parent Item:	D2325			Start Date: 5/21/2013		Required Date: 5/22/2013		
Parent Item Name:	Support Gusset (350 Basket)			Start Qty: 4.00		Required Qty: 4.00		

Comments: IPP   D02.12.06 Reformat; Rev BKJ/RF
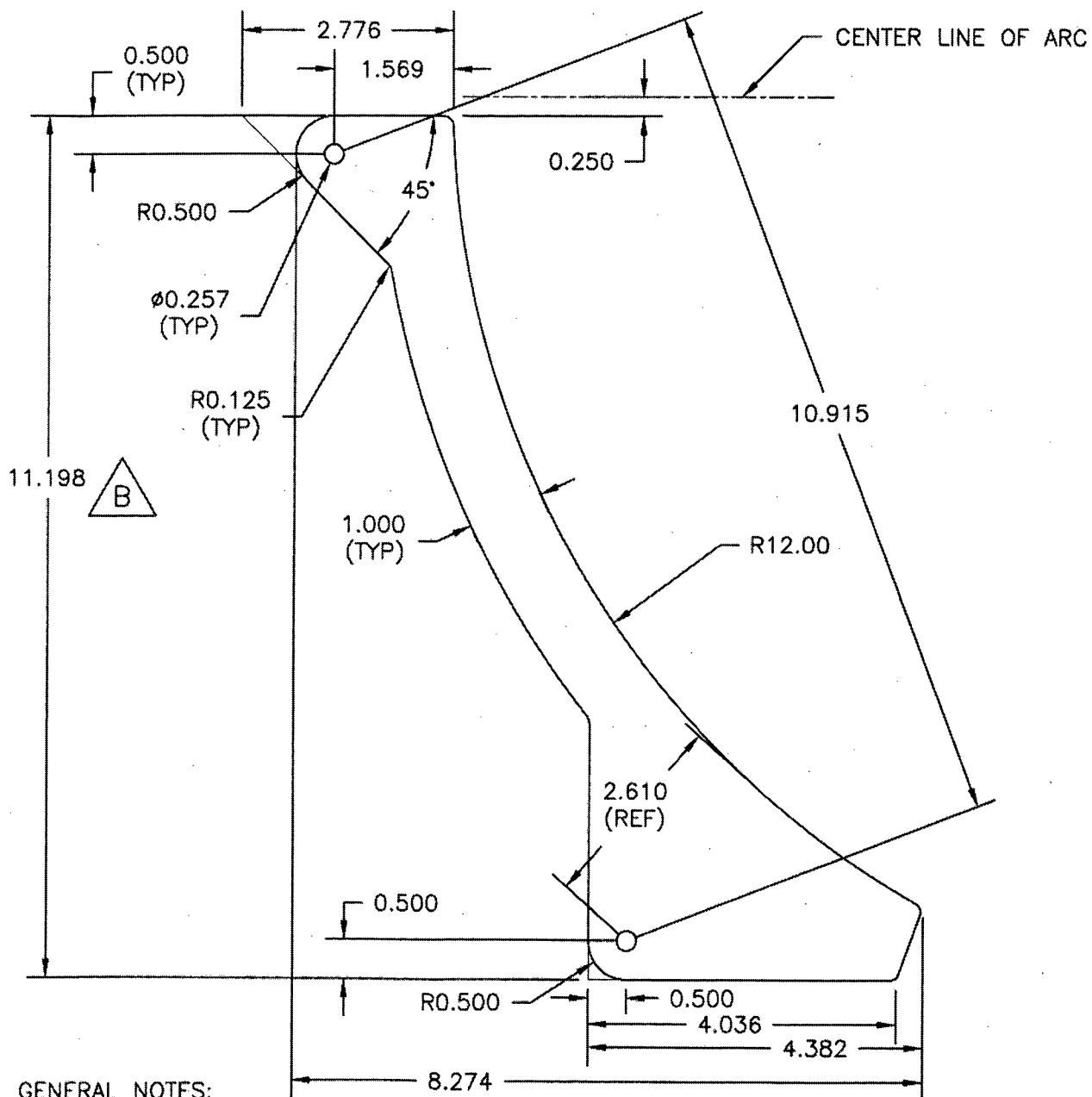IPP   E06.05.03 Water jet   EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	453.8742	0.465	~~1.9578947~~ 0.75		Jm 13-5-21	

	Location	Loc Qty	Loc Code
	MAT020	453.8741688	
	122245	0.1713688	
	123136	140.8	
	124428	28.35	
	124572	28.5528	124572
	125599	256	

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2325	SHEET 1 OF 1
DATE		TITLE	SCALE
02.08.28		SUPPORT GUSSET	1:2

A		94.12.13	NEW ISSUE
B		02.08.28	REFORMAT; 11.198 WAS 11.948

RELEASED
02.08.29

CENTER LINE OF ARC

2.776
1.569
0.500 (TYP)
0.250
45°
R0.500
Ø0.257 (TYP)
R0.125 (TYP)
10.915
11.198 B
1.000 (TYP)
R12.00
2.610 (REF)
0.500
R0.500
0.500
4.036
4.382
8.274

<u>GENERAL NOTES:</u>
1) MATERIAL: AISI 304/316 SS SHEET, 0.063" THICK (REF DART SPEC. M304S16GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

DART AEROSPACE LTD		Work Order:	10191
Description: Support Gusset		Part Number:	D2325
Inspection Dwg: D2325 Rev: B			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0.259"	✓		V	Jkmol
1.000	+/-0.010	1.006"	✓		V	
0.500	+/-0.010	0.501"	✓		V	
4.382	+/-0.010	4.380"	✓		V	
10.915	+/-0.010	10.913"	✓		V	Produno2
1.569	+/-0.010	1.569"	✓		V	

Measured by:	Jm	Audited by:		Prototype Approval:	N/A
Date:	13-5-21	Date:	13 5 21	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	06.05.08	New Issue		KJ/JLM	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved										

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
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☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	